ABSTRAK

PT. Himalaya Transmeka adalah perusahaan yang bergerak dibidang industri dan manufaktur dalam pembuatan produk *Electrical Switch Board Motor Control Center* (Panel Listrik). Objek penelitian pada penelitian ini adalah produk Panel Listrik Tipe *Wall Mounting*. Pemborosan yang terjadi di sepanjang lantai proses produksi yang merugikan pihak perusahaan dan menurunkan performansi perusahaan perlu dilakukan upaya untuk meminimisasi *waste* tersebut. Tahapan yang dilakukan adalah dengan menggambarkan lini produksi Panel Listrik *Tipe Wall Mounting* saat ini dengan metode *Value Stream Mapping* (VSM) serta digunakan beberapa *tools* seperti *Kanban System* dan perhitungan *Takt Time* untuk menganalisa pemborosan yang terjadi di dalam lini produksi Panel Listrik Tipe *Wall Mounting*. Berdasarkan hasil perhitungan *Current State Value Stream Map* maka diketahui aktifitas *Value Added* sebesar 99.086,78 detik dan *Non Value Added* sebesar 43,29 hari. Sedangkan hasil perhitungan *Future State Value Stream Map* untuk nilai *Value Added* dan *Non Value Added* secara berturut – turut adalah 99.086,78 detik dan 9,5 hari. Untuk aktifitas *Non Value Added* mengalami penurunan sebanyak 78,055%. Pada perhitungan *takt time*, didapatkan *takt time* sebesar 9845,902 detik, dimana ada dua proses yang *cycle time*nya melebihi *takt time*, yaitu proses *wiring assembling* dengan *cycle time* sebesar 70.015,1 detik dan proses *quality control* dengan *cycle time* 17.510,55 detik. Sehingga proses tersebut dapat dikatakan belum baik karena berjalan lebih lambat daripada yang seharusnya. Selanjutnya dilakukan perhitungan *Value Added Ratio* yang hasilnya didapatkan untuk *Current State Value Stream Map* sebesar 8,384% dan *Future State Value Stream Map* sebesar 38,206%.

Kata Kunci : *Wall Mounting, Value Stream Mapping* (VSM), *Takt Time, Value Added Time, Non Value Added Time, Value Added Ratio*

ABSTRACT

PT. Himalaya Transmeka is a company engaged in the manufacturing industry and producing product of Electrical Switch Board Motor Control Center. The object of research in this final report is the product of Electrical Panel Wall Mounting Type. The waste that occurs along the floor of the production process to the detriment of the company and lower the performance of the company that need to be made to minimize waste. Steps being taken is to describe the type of production lines current of Electrical Panel Wall Mounting with Value Stream Mapping (VSM) method and use some tools like Kanban System and calculation Takt Time to analyze the waste that occurs in the production line Electrical Panel Wall Mounting Type. Based on the results of the calculation of the Current State Value Stream Map the known activity of 99.086,78 seconds for Value Added and Non-Value Added amounted to 43,29 days. While the results of the calculation of Future State Value Stream Map of Value Added and Non-Value Added in a row - also is 99.086,78 seconds and 9.5 days. For Non Value Added activities decreased by 78,055%. In the takt time calculation, obtained by 9845.902 seconds takt time, where there are two processes that cycle timenya exceeds takt time, the process of assembling the wiring of 70015.1 sec cycle time and process quality control with cycle timet 17510.55 seconds. So that the process can be said to be not good because running slower than it should. Furthermore, the calculation of Value Added Ratio is the result obtained for the Current State Value Stream Map of 8,384% and Future State Value Stream Map of 38,206%.

Key Words : Value Stream Mapping (VSM), Takt Time, Value Added Time, Non Value Added Time, Value Added Ratio